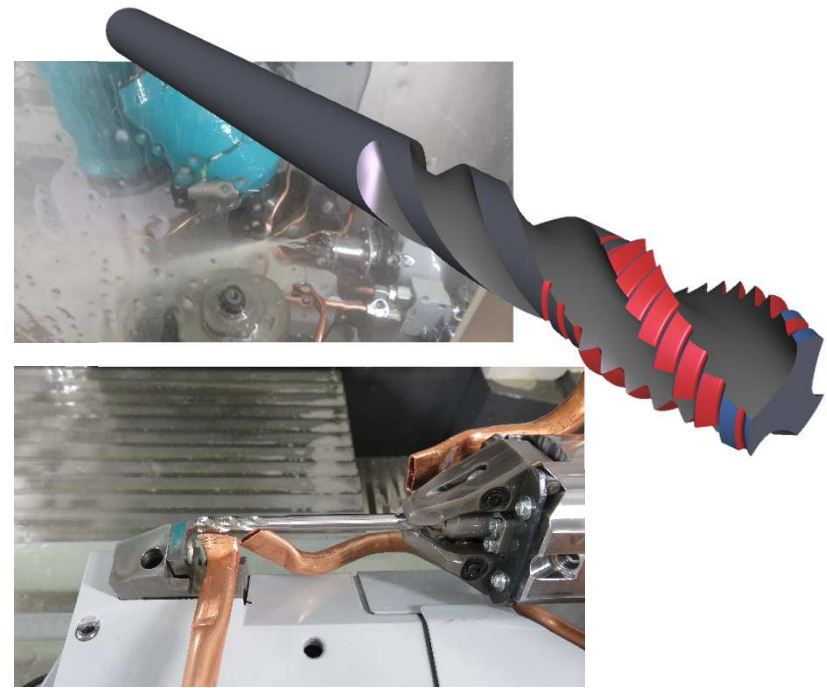


Tap M6 Ø6.1, Z3, Helix 35°

A10-020

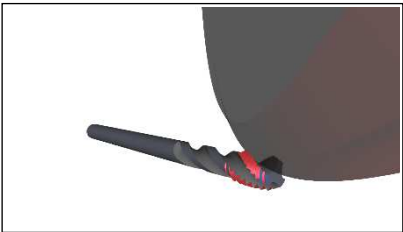


Tool
The 3 fluted helical Tap M6 is ground from solid cylindrical blank between centers. A special clamping acts as dog and drive system on the square at the shafts end. Flutewheel and threading Formwheel are dressed in the cycle.

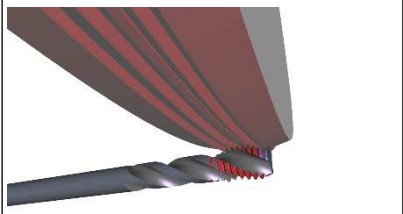
Blank
Dimension: Ø 6.15/ Ø 5/ Ø 6 mm, L 80mm
HSS

N° / Process description
Feed rate / Wheel / Time

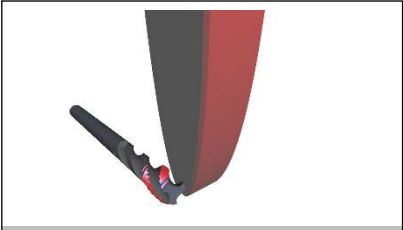
1 / Plungedress Threadwheel
0.4 mm/min / ③ / 20 s



1 / Flute
2200 mm/min / ① / 62 s



3 / Thread
50 mm/min / ③ / 29 s



4 / Chamfer
50 mm/min / ② / 25 s



Total cycle time: 2 Min 16 s

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

SCHNEEBERGER

Machine / Configuration

- Machine: Gemini NGM TAP Robot
- Control: Fanuc 31iB
- Accessories: 2 Dressing Units, Tailstock for Taps,

Wheels / Wheel packs

